

Work Order ID 71699

Thursday, July 07, 2011 12:56:40 PM



Page 1

Item ID: D4055-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Aft End

Start Date: 7/7/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/07/07 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4055	B

100 0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4055

Prog rev: S

Dwg rev: B

B11-8-3

4

110 0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B11-8-3

120 0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

S u l o s / o s

x4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Sp 11/03/08

4

Brake NC

140

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

S 11/03/08

4

Quality Control

141

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

4x Ø m 11/08/08

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D4055-3

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Setup Start



Revision ID:

Item Name: Tank Aft End

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Start Date: 7/7/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

142

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 9 11/08/10

150

Identify as per dwg & Stock Location: *WA*

0.00



Packaging

Memo

0.00

Packaging

11-08-10

φ

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/08/11

11-08-10
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, July 07, 2011 12:56:37 PM

Page 1

Work Order ID: 71699

Parent Item: D4055-3

Parent Item Name: Tank Aft End



Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM
10.11.23 now made in house DD verf:EC

IPP rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

100

sf

212.9456

1.5143

6.376



B11-8-3

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

212.9455684

116308

28.4755684

117285

184.47

117 285

(4)

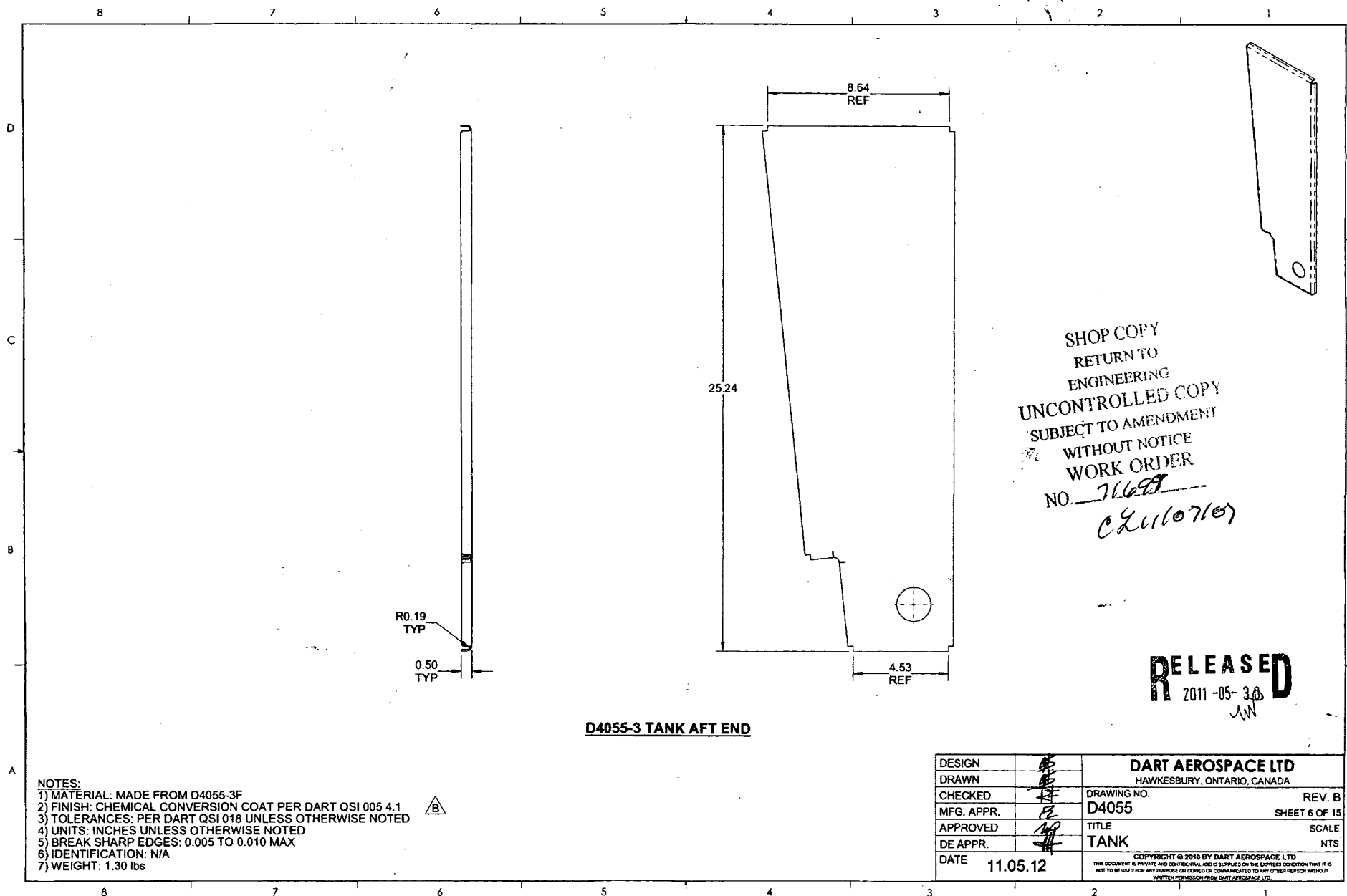
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

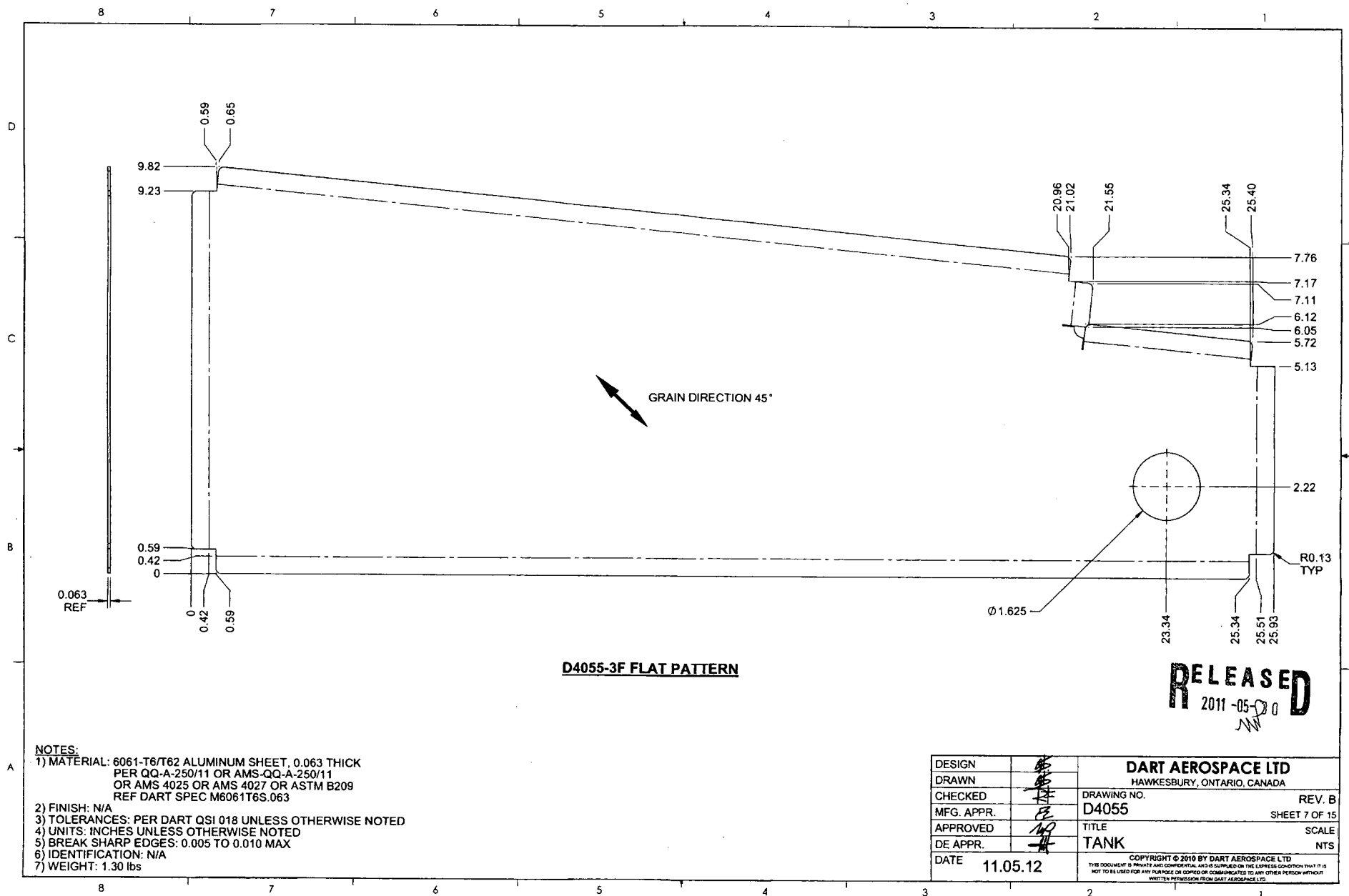
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	71699
Description: Tank Aft End		Part Number:	D4055-3
Inspection Dwg: D4055	Rev: A B A 11.08.03	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.42	+/-0.030	BEND			X	
0.59	+/-0.030	.593	*		V B02	
9.23	+/-0.030	9.23	2		V	
9.82	+/-0.030	9.82	2		V	
0.59	+/-0.030	.592	2		V	
0.65	+/-0.030	.658	2		V	
23.34	+/-0.030	23.34	2		T B01	
25.34	+/-0.030	25.34	*		T	
25.51	+/-0.030	BEND			T	
25.93	+/-0.030	25.93	2		T	
2.22	+/-0.030	2.217	2		V	
5.13	+/-0.030	5.134	2		V	
5.72	+/-0.030	5.724	2		V	
6.05	+/-0.030	6.05	2		V	
6.12	+/-0.030	6.114	2		V	
7.11	+/-0.030	7.117	2		V	
7.17	+/-0.030	7.175	2		V	
7.76	+/-0.030	7.759	2		V	
20.96	+/-0.030	20.96	2		T	
21.02	+/-0.030	21.02	2		T	
21.55	+/-0.030	21.55	2		T	
25.34	+/-0.030	25.34	2		T	
25.40	+/-0.030	25.40	2		T	
0.063	+/-0.010	.061	*		V	

Measured by:	B
Date:	11-8-3

Audited by:	S
Date:	11/08/03

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	11.01.18	New Issue	KJ	